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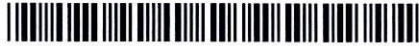
D3560-041
Job Sheet 173041



Part No: D3560-041

Job Qty: 2 ea

Part Name: Arm Weldment



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/26/18

Job Tracking No:

Due Date: 3/13/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV D IPP Rev:A New Issue 07.05.24 EC IPP rev B ECN 987 07.10.09 EC verified by: DD IPP Rev:C
ECN1048 07-12-18 DD verified by: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		3/12/18	0.00	0.00	Start Up Large Fab-4		18-02-26
140	Large Fab	2 pcs		3/12/18	0.00	1.63	Large Fab 2		CPC
150	QC	2 pcs		3/12/18	0.00	0.00	QC5		PD 18-02-23
160	QC	2 pcs		3/12/18	0.00	0.00	QC9		PD 18-02-23
170	HandFinish	2 pcs		3/12/18	0.00	0.25	HandFinish1		18-03-01
180	QC	2 pcs		3/12/18	0.00	0.00	QC7-2		CP
190	Small Fab	2 pcs		3/13/18	0.00	0.06	Small Fab-4		CP
200	QC	2 pcs		3/13/18	0.00	0.00	QC5		CP
210	Packaging	2 pcs		3/13/18	0.00	0.00	Packaging3-1		CP
220	QC21-SA	2 Ea		3/13/18	0.00	0.00	QC21		

Part Op 140 - 1-Weld assembly as per dwg D3560 STEP: 1- clean material (buff bracket and bottom of arm with blue pad) 2- set Descriptions: up bracket and arm on jig 3- preheat bracket and arm with torch 4- clean before welding with brush 5- set up machine to 135 amps 6- weld across bottom and top ends 7- reheat with torch (65 deg C) 8- on one side weld from bottom to top half way 9- same for other side (half way) 10- from half way point weld the rest of the first side (ease off pedal near end) 11- same for remaining side (ease off pedal near end)

190 - 1-Press bushing in D3560 arm per dwg D3562

210 - *** STOCK IN STEP CELL*** LOCATION: WA003

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3560-1	Arm	2 Ea (1 ea)	90-Start up Operation	F 149444
D3592-1	Plate	2 Ea (1 ea)	90-Start up Operation	F 164497
D2808	Spacer	2 Ea (1 ea)	190-Small Fab	F 164464

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3560-1	2	0	0
	D3592-1	2	28	0
190-Small Fab	D2808	2	30	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Part Specifications
Specifications could not be found.

Plex 2/26/18 7:37 AM dart.lacelle.linda

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Container No: S045608



Part: D3560 - 041

Job No: 173041

Serial No/Batch: S045608

Revision: D3560

Inspector:

Date: 02/28/18

Master Unit 001191



Job No 173041

UPDATE

Work Order update only ☐



AGAINST DEPARTMENT/PROCESS

☐	Cross tube	☐	Water Jet	☐	Engineering	☐
☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
☐	Composite	☐	Supplier	☐		☐

ve :

MRB (QSI042) Approval

Disposition

Completed By

Lead hand/ Supervisor
Approval Verification

QC / QA Coordinator
Approval

FAULT CATEGORY

☐	Power Loss/Surge	☐	Positioned Wrong
☐	Folio/Program	☐	Outside Dimensions
☐	Grain	☐	Over/Under tolerance
☐	Weld	☐	Part Incorrect
☐	Wrong Stock Pulled	☐	Part Lost/Missing
☐	Out of Sequence	☐	Part Moved
☐	Off-set	☐	Drawing
☐	Mislabeled	☐	Finish
☐	Fit/Function	☐	Misread
☐	Misaligned/off center	☐	Turning Sequence